

SPLIT

POSITIVE RECALL

EFFECTIVE 07/06/07 AUTH LL

## Process Sheet

Date: Thursday, 5/31/2007 7:23:16 AM  
 User: Kim Johnston

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 32718-1

Estimate Number : 12576

P.O. Number : N/A

This Issue : 5/31/2007

S.O. No. : N/A

Prsh Rev. : NC

First Issue : N/A

Type : LARGE FAB ASSY

Previous Run : 29411

Written By :

Checked &amp; Approved By :

Comment : Est Rev:A New Issue 06-11-09 JLM

Drawing Name

: STEP RELEASED 07/06/07 DATE

Part Number : D3562041

Drawing Number : D3562 UNDER REVIEW

Project Number : N/A

Drawing Revision : A

Material : N/A

Due Date : 6/11/2007

Qty:

Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion B31984

Check Material for any Dents or Defects

PL. 07.06.07H

2.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2734 End Cap 329340 = 1  
B30883 = 9PL. 07.06.07H

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

PL. 07.06.07⑤

2-Deburr and bevel ends for welding

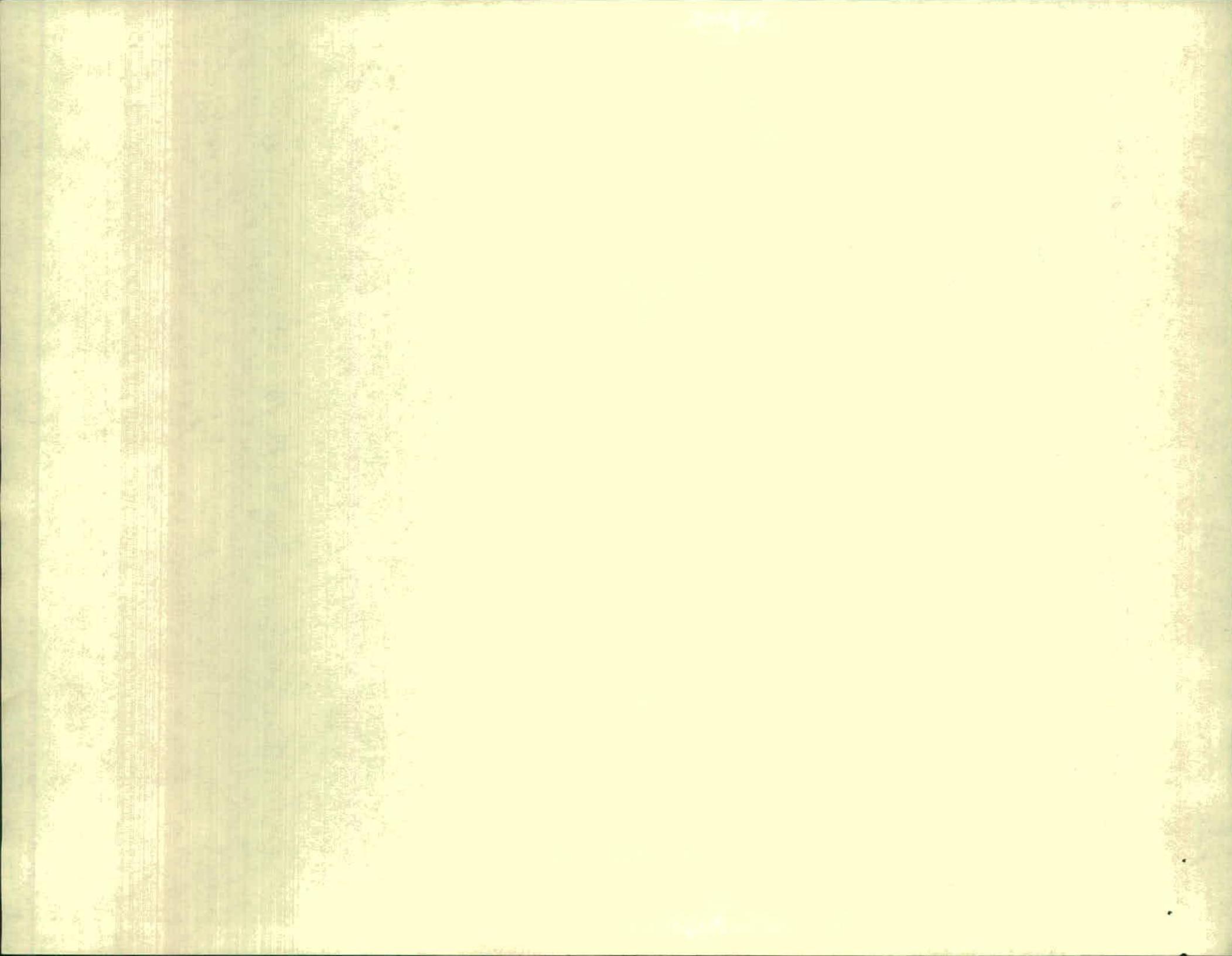
PL. 07.06.07PL. 07.06.07H

3-Weld (1)end cap as per Dwg D3562&amp; QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M102756

4-Grind end cap welds flush as per Dwg D3562

PL. 07.06.07H



day, 5/31/2007 7:23:16 AM  
Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32718

Part Number: D3562041

Job Number:



Seq. #:	Machine Or Operation:	Description:
4.0	QC5	INSPECT WORK TO CURRENT STEP <i>QC5 20706-07 (5)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>b:0</i> <i>debur</i> <i>Touch holes Alodide</i> <i>VP with</i> <i>Drill Rivet holes as per dwg D3562. USING DT 8956 w/AGJM</i>
6.0	QC5	INSPECT WORK TO CURRENT STEP
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
9.0	D3560041	ARM WELDMENT
10.0	D3560043	ARM WELDMENT
11.0	MS20600AD4W5	Blind Rivet

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
- ARM WELDMENT  
Batch: *B32643* *EE. 07-06-07*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
ARM WELDMENT  
Batch: *B32646* *EE. 07-06-07*

Comment: Qty.: 36.0000 Each(s)/Unit Total : 180.0000 Each(s)  
Blind Rivet *Q+X34* *SEE W/J CHANGE*  
batch: *012042* *34* *EE. 01-06-07*



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32718

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1



SL - 07.06.13

4

Rivet legs using Magnabond as per dwg D3562.

Ensure to wipe off any excess magnabond of the step

A/R Magnabond 6398

Batch: M103628

SL 07.06.13

4

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Test Fitted on A/C.

14.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562&amp; QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M102760

SL - 07.06.14

4

2-Grind end cap welds flush as per Dwg D3562

SL a.m

07.06.14

4

15.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

LH

④

16.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

LH

17.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL

07.06.15

④

18.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



FX

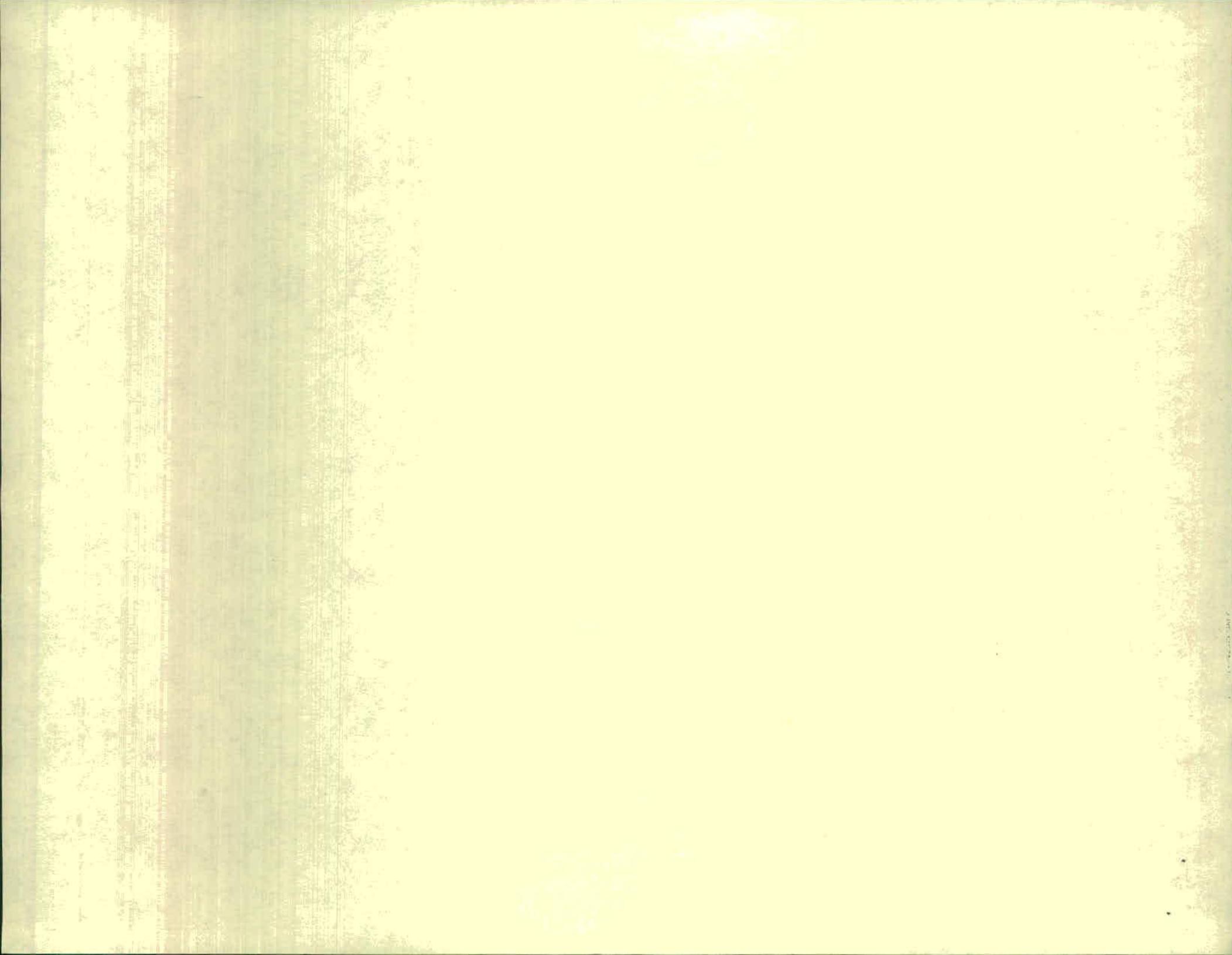
Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch:

M104281

m-h 07/06/15



Wednesday, 5/31/2007 7:23:16 AM

Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32718

Part Number: D3562041

Job Number:



Seq. #:	Machine Or Operation:	Description :
19.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		mf 07-06-18
20.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Assembly Kit		RP 07/06/19

Job Completion

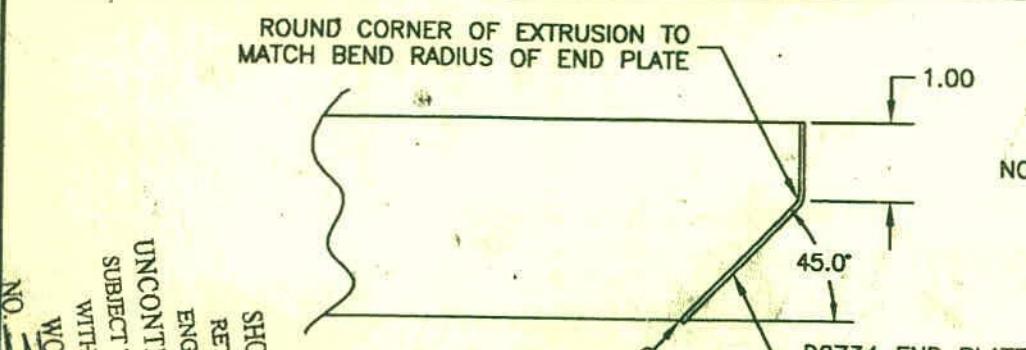


### POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_  
RELEASED u DATE 07/06/19







NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

**DART**

RELEASED  
07.02.2007

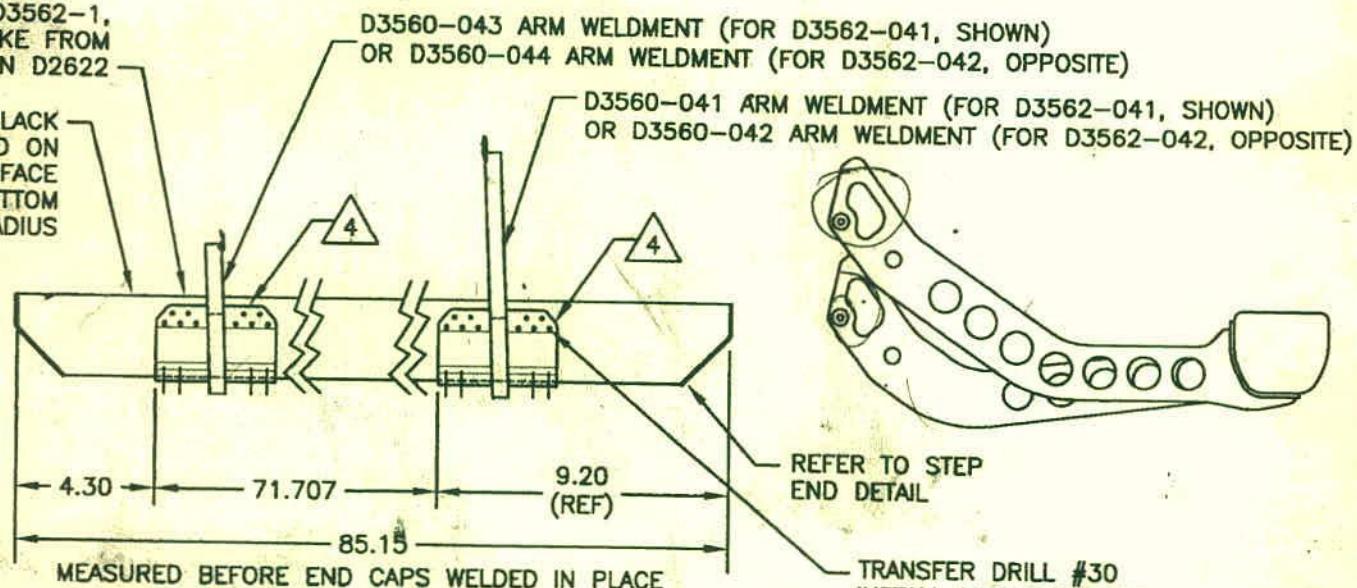
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 32718

D3562-1,  
MAKE FROM  
EXTRUSION D2622

APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

FWD



#### D3562-041 LH STEP ASSEMBLY (SHOWN)

#### D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004
- 3) FINISH:

AFTER WELDING END PLATES AND PRIOR TO DRILLING/INSTALLING ARM WELDMENTS:

- i) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- ii) POWDER COAT GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)  
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3
- iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

- 4) INSTALL ARM WELDMENTS WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS-B2 SEALANT BETWEEN THE ARM WELDMENT AND STEP EXTRUSION
- 5) ALL DIMENSIONS ARE IN INCHES

TRANSFER DRILL #30  
INSTALL MS20600AD4W5  
RIVET (36 PLACES),  
DEBURR & TOUCH UP HOLES  
WITH CHEMICAL CONVERSION  
COAT BEFORE RIVETING,  
TOUCH-UP RIVET HEADS  
WITH PAINT PER  
DART QSI 005 4.2

MAGNAIROND  
P07.06.07

REF IS EMAIL

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.
		HAWKESBURY, ONTARIO, CANADA
DATE		SHEET 1 OF 1
07.01.15		SCALE
		NTS
A	06.09.26	TITLE
B	07.01.15	STEP ASSEMBLY
		D3562
		ARMS NOW RIVETED TO STEP

